

Work Order ID 129288

Tuesday, February 03, 2015 7:37:31 AM

129288

Page 1

Item ID: D3821-3KIV

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel W/ Rotor Brake-Ivory

Start Date: 2/3/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *15-02-03* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
3821-3	Rev. B

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x 1

DAS
07
9-89

15/01/27

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

x 1

DAS
07
9-89

15/01/27

Temp: **245 deg. F**

JAN 26 2015

Time IN: **5:00 PM**

Time OUT: **6:00 AM**

Per... *Sh*

Work Order ID 129288***129288***

Page 2

Item ID: D3821-3KIV

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel W/ Rotor Brake-Ivory

Start Date: 2/3/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
DAS
07
9-09

110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA024 using tool DT9054

Dwg Rev: BFolio Rev: A

Visually inspect for proper formation of each part

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

15/01/07

B15/02/03

Work Order ID 129288

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Page 3

Item ID: D3821-3KIV

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel W/ Rotor Brake-Ivory

Start Date: 2/3/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

150

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control	1-Complete FAI document								
-----------------	-------------------------	--	--	--	--	--	--	--	--

160	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

160

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

170	Identify as per dwg & Stock Location: <u>PE6</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

170

Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging									
-----------	--	--	--	--	--	--	--	--	--

B15/02/03

DAS
38
9-89

FEB 13 2015

63-9
99
DAS

FEB 21 2015

Work Order ID 129288

Tuesday, February 03, 2015 7:37:31 AM

129288

Page 4

Item ID: D3821-3KIV

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel W/ Rotor Brake-Ivory

Start Date: 2/3/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

15/2/23

2-23

Picklist Print

Tuesday, February 03, 2015 7:37:37 AM

Page 1

Work Order ID: 129288

129288

Parent Item: D3821-3KIV

D3821-3KIV

Parent Item Name: Panel W/ Rotor Brake-Ivory

Start Date: 2/3/2015

Required Date: 2/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased			No	100	sf	3,024.163	12.7969	13			DAS 07 9-89

MKYD6185S 080-P3-62015

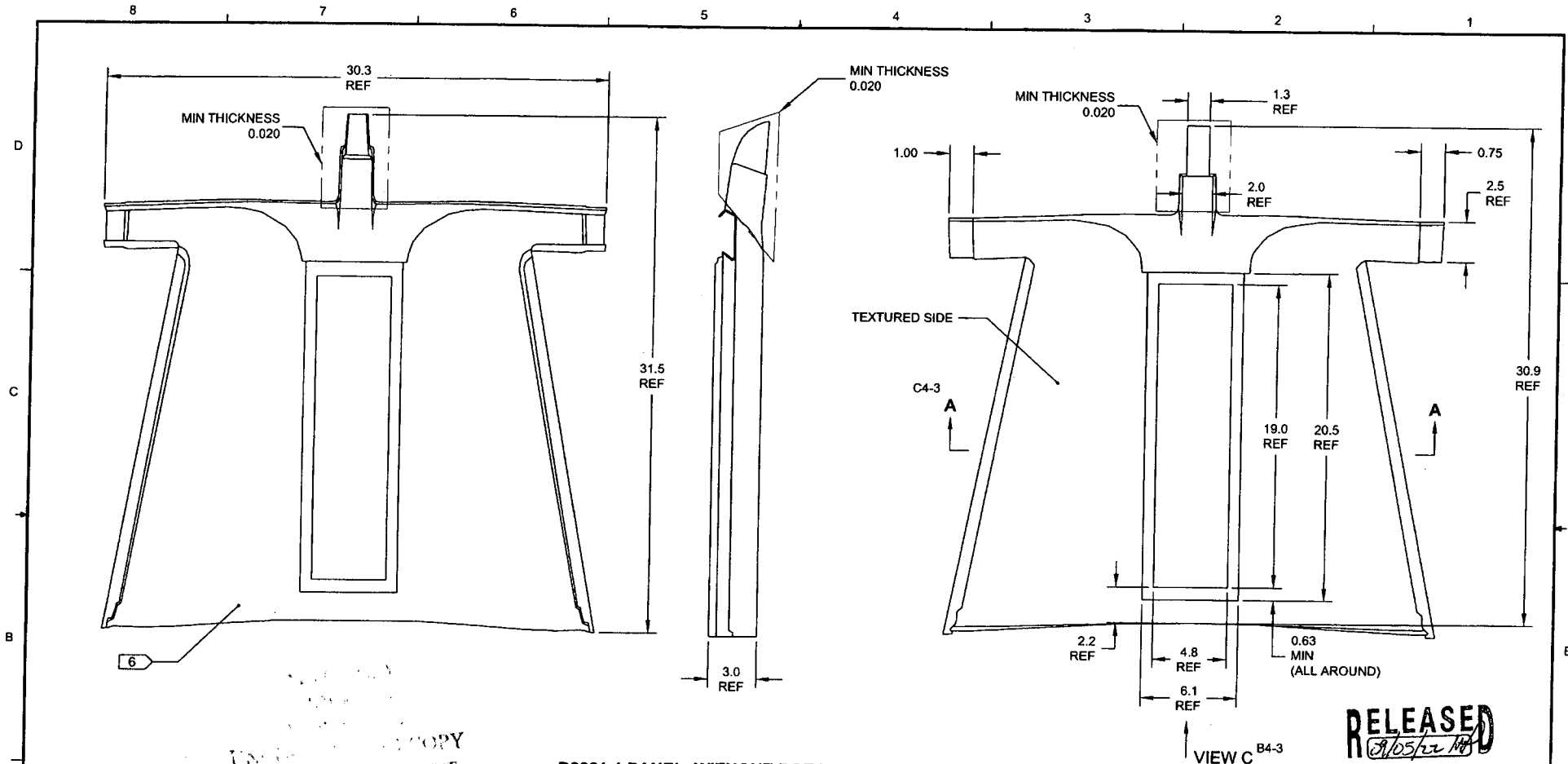
**

Kydex Ivory (52"x96"-.080)

15/01/27

Location	Loc Qty	Loc Code
LAIRD	1178.6633	
m129761	797.33	
m130671	381.3333	
therm	1845.5	
116576	6.5	
121755	92	
124462	1053	
m127758	347	
m128322	347	

1359 ft



D3821-1 PANEL, WITHOUT ROTOR BRAKE
(BELL 206 A/B)

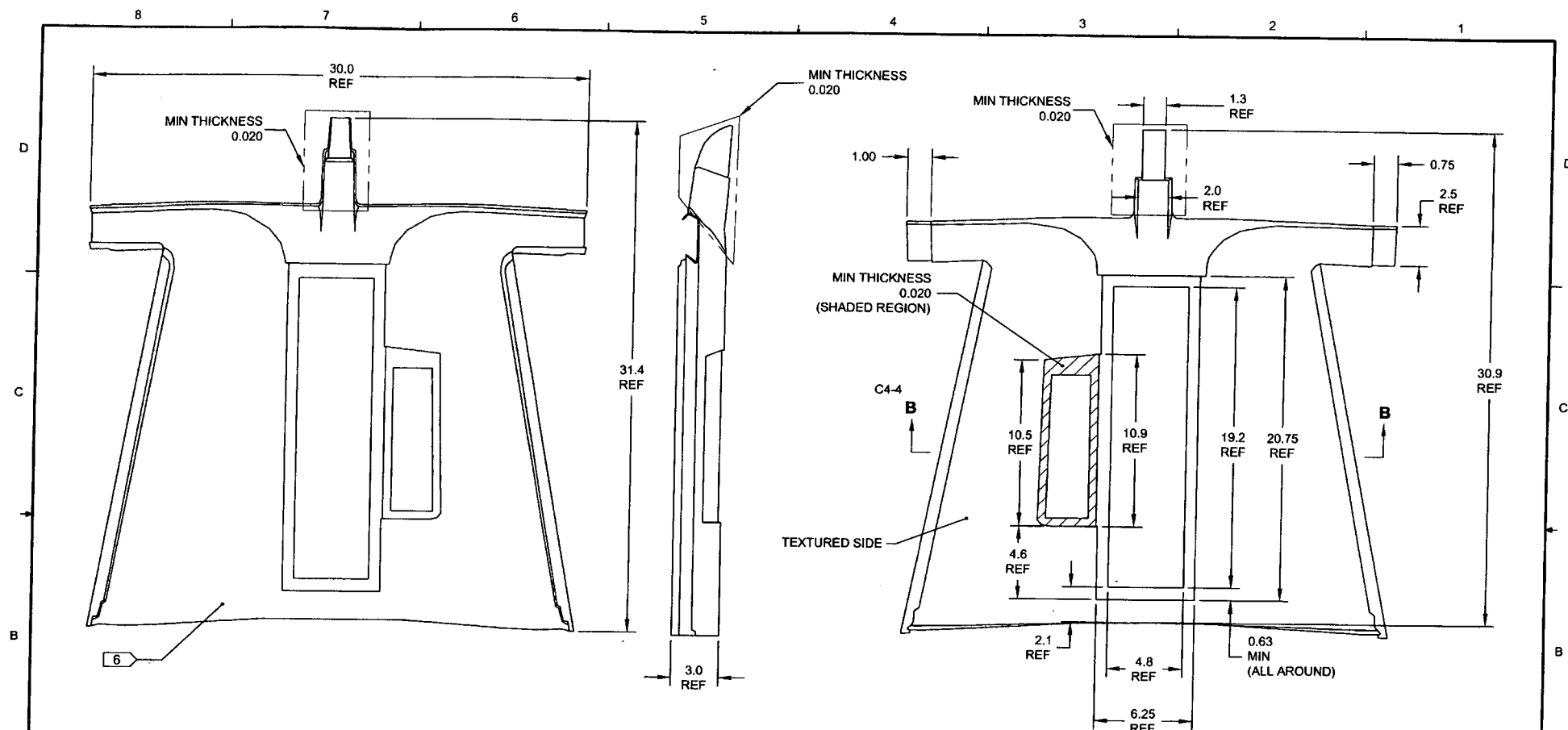
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9053 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3821-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	ADD STEEL GRAY COLOUR OPTION. ADD IVORY P/N'S D3821-1KIV, D3821-3KIV AND ADD STEEL GRAY P/N'S D3821-1KGY, D3821-3KGY (ZN A5-1, A5-2)		PH	09.05.05
	NEW ISSUE		PH	08.09.29
REV.	DESCRIPTION		BY	DATE
DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B	
CHECKED	DRAWING NO. D3821		SHEET 1 OF 4	
MFG. APPR.	TITLE PANEL (BELL 206 A/B)		SCALE	
APPROVED	DATE 09.05.05		NTS	
DE APPR.	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
09/05/2005



D3821-3 PANEL, WITH ROTOR BRAKE
(BELL 206 A/B)

VIEW D B4-4

RELEASED
09/05/22

NOTES:

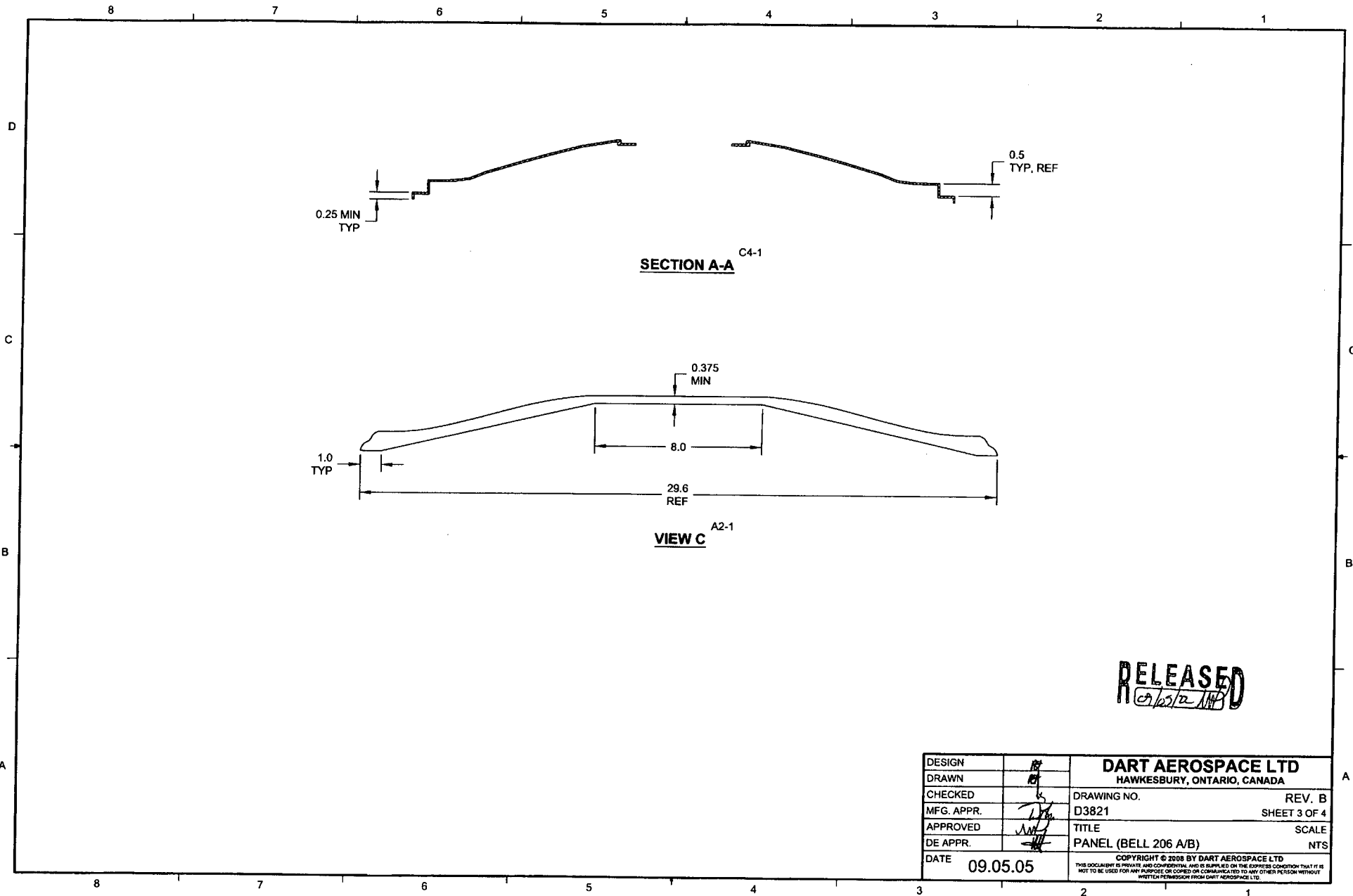
- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9054 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3821-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

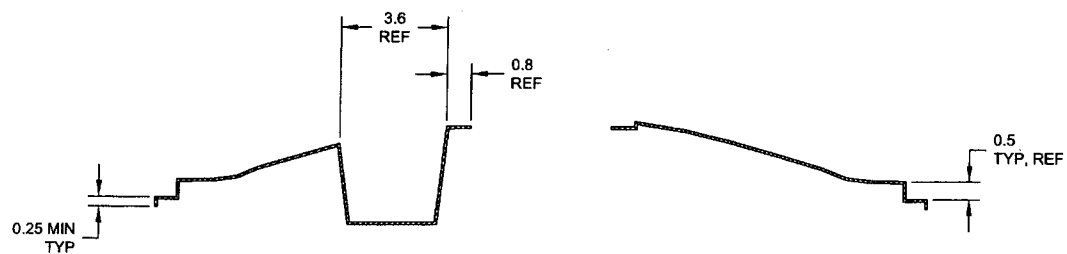
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3821 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		PANEL (BELL 206 A/B) NTS
DATE	09.05.05	

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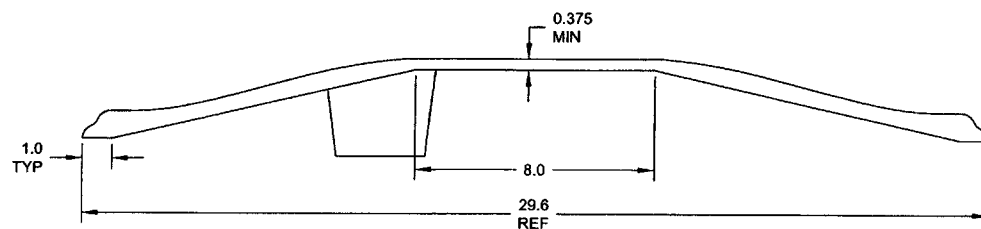


RELEASED
09/05/05

DESIGN	18	DART AEROSPACE LTD	
DRAWN	18	HAWKESBURY, ONTARIO, CANADA	
CHECKED	18	DRAWING NO. D3821	REV. B
MFG. APPR.	18	SHEET 3 OF 4	
APPROVED	18	TITLE	SCALE
DE APPR.	18	PANEL (BELL 206 A/B)	NTS
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SECTION B-B C4-2



VIEW D C4-2

RELEASED
09/05/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3821	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL (BELL 206 A/B)	NTS
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DART AEROSPACE LTD	Work Order:	129 288
Description: Panel, ^{WITH} without Rotor Brake	Part Number:	D3821-3 KIV/KGY
Inspection Dwg: D3821-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>JB</u>	Date: 15/02/03
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	Min	1.03	✓		DL-02	
0.75	Min	.769	✓		DL-02	
0.63	Min	.684	✓		DL-02	
0.25	Min	.312	✓		DL-02	
0.375	Min	.42	✓		DL-02	

Measured by: <u>JB</u>	Date: 15/02/03
Audited by: <u>SD</u>	Date: 15-02-13
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<u>JA</u>